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**647.7401**  
**Job Sheet 190594**



008711

**Part No:** 647.7401

**Job Qty:** 2 pcs

**Part Name:** Upper Cutter Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/11/19

**Job Tracking No:**

**Due Date:** 2/28/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG REV B IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

SLOP

**Ship Via:**

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty   | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off |
|----------|------------------------|-------|------------|-------------|--------------|------------|-----------------------|-----------|----------|
|          |                        |       |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |          |
| 110      | Packaging 1 - Pick Kit | 2 pcs | 2/28/19    |             | 0.00         | 0.00       | Packaging 1 - 1       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 2       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 3       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 4       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 5       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 6       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 7       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 8       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 9       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 10      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 11      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 12      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 13      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 14      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 15      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 16      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 17      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 18      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 19      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 20      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 21      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 22      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 23      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 24      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 25      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 26      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 27      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 28      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 29      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 30      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 31      |           |          |

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|                                 |       |         |           |  |                        |             |
|---------------------------------|-------|---------|-----------|--|------------------------|-------------|
|                                 |       |         |           |  | Packaging 1 - 32       |             |
|                                 |       |         |           |  | Packaging 1 - 33       |             |
|                                 |       |         |           |  | Packaging 1 - 34       |             |
|                                 |       |         |           |  | Packaging 1 - 35       |             |
|                                 |       |         |           |  | Packaging 1 - 36       |             |
|                                 |       |         |           |  |                        |             |
| 120 Small Fab - 2 - B4B         | 2 pcs | 2/28/19 | 0.00 2.17 |  | Small Fab - 1 - B4B    |             |
|                                 |       |         |           |  | Small Fab - 2 - B4B    |             |
|                                 |       |         |           |  | Small Fab - 3 - B4B    |             |
|                                 |       |         |           |  | Small Fab - 4 - B4B    | JUN 20 2019 |
|                                 |       |         |           |  | Small Fab - 5 - B4B    |             |
|                                 |       |         |           |  | Small Fab - 6 - B4B    |             |
|                                 |       |         |           |  | Small Fab - 7 - B4B    |             |
| 130 QC 5                        | 2 pcs | 2/28/19 | 0.00 0.00 |  | QC 5 - 10              |             |
|                                 |       |         |           |  | QC 5 - 12              |             |
|                                 |       |         |           |  | QC 5 - 17              |             |
|                                 |       |         |           |  | QC 5 - 18              |             |
|                                 |       |         |           |  | QC 5 - 19              |             |
|                                 |       |         |           |  | QC 5 - 22              |             |
|                                 |       |         |           |  | QC 5 - 24              |             |
|                                 |       |         |           |  | QC 5 - 3               |             |
|                                 |       |         |           |  | QC 5 - 42              |             |
|                                 |       |         |           |  | QC 5 - 43              |             |
|                                 |       |         |           |  | QC 5 - 49              |             |
|                                 |       |         |           |  | QC 5 - 51              |             |
|                                 |       |         |           |  | QC 5 - 58              |             |
|                                 |       |         |           |  | QC 5 - 68              |             |
|                                 |       |         |           |  | QC 5 - 9               |             |
| 140 Packaging 3-1 - Stock - B4B | 2 pcs | 2/28/19 | 0.00 0.00 |  | QC 5 - 50              | JUN 21 2019 |
|                                 |       |         |           |  | QC 5 - 30              |             |
|                                 |       |         |           |  | Packaging 3 - 1 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 2 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 3 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 4 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 5 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 6 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 7 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 8 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 9 - B4B  |             |
|                                 |       |         |           |  | Packaging 3 - 10 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 11 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 12 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 13 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 14 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 15 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 16 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 17 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 18 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 19 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 20 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 21 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 22 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 23 - B4B | PC CC K032  |
|                                 |       |         |           |  | Packaging 3 - 24 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 25 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 26 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 27 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 28 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 29 - B4B |             |
|                                 |       |         |           |  | Packaging 3 - 30 - B4B |             |



|                |       |         |           |                 |                        |  |
|----------------|-------|---------|-----------|-----------------|------------------------|--|
|                |       |         |           |                 | Packaging 3 - 31 - B4B |  |
|                |       |         |           |                 | Packaging 3 - 32 - B4B |  |
|                |       |         |           |                 | Packaging 3 - 33 - B4B |  |
|                |       |         |           |                 | Packaging 3 - 34 - B4B |  |
|                |       |         |           |                 | Packaging 3 - 35 - B4B |  |
|                |       |         |           |                 | Packaging 3 - 36 - B4B |  |
| 150 QC 21 - SA | 2 pcs | 2/28/19 | 0.00 0.00 | QC 21 - SA - 21 |                        |  |
|                |       |         |           | QC 21 - SA - 70 |                        |  |
|                |       |         |           | QC 21 - SA - 53 |                        |  |

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE

598: \_\_\_\_\_ exp. date: \_\_\_\_\_

130 - QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_) \*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV\*\*\*

150 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item            | Component Name                | Quantity       | Operation                  | Container      |
|------------------------|-------------------------------|----------------|----------------------------|----------------|
| 646.3015 <i>cek102</i> | Blade                         | 4 Ea (2 ea)    | 110-Packaging 1 - Pick Kit | <i>5136629</i> |
| 647.7610 <i>066</i>    | Upper Deflector               | 2 pcs (1 ea)   | 110-Packaging 1 - Pick Kit | <i>5129080</i> |
| 647.7810 <i>77A</i>    | Bracket A                     | 2 pcs (1 ea)   | 110-Packaging 1 - Pick Kit | <i>5115101</i> |
| 647.7811 <i>77A</i>    | Bracket B                     | 2 pcs (1 ea)   | 110-Packaging 1 - Pick Kit | <i>5114688</i> |
| 647.7812 <i>cek110</i> | Center Plate, Upper           | 2 pcs (1 ea)   | 110-Packaging 1 - Pick Kit | <i>5156295</i> |
| MS21042-3 <i>5T</i>    | Nut use MS21042L3 per QSI 017 | 6 Ea (3 ea)    | 110-Packaging 1 - Pick Kit | <i>5134220</i> |
| MS21042L08             | Nut                           | 26 Ea (13 ea)  | 110-Packaging 1 - Pick Kit | <i>5134219</i> |
| MS27039-08-19          | Screw                         | 12 Ea (6 ea)   | 110-Packaging 1 - Pick Kit | <i>5104359</i> |
| MS27039-08-23          | Screw                         | 14 Ea (7 ea)   | 110-Packaging 1 - Pick Kit | <i>5155680</i> |
| MS27039-1-19           | Screw                         | 6 Ea (3 ea)    | 110-Packaging 1 - Pick Kit | <i>5155664</i> |
| NAS1149F0332P          | Washer                        | 12 Ea (6 ea)   | 110-Packaging 1 - Pick Kit | <i>5157648</i> |
| NAS1149FN832P          | Washer                        | 136 Ea (68 ea) | 110-Packaging 1 - Pick Kit | <i>5143716</i> |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 110-Packaging 1 - Pick Kit | 646.3015       | 4        | 61        | 0         |
|                            | 647.7610       | 2        | 9         | 0         |
|                            | 647.7810       | 2        | 38        | 0         |
|                            | 647.7811       | 2        | 39        | 0         |
|                            | 647.7812       | 2        | 1         | 0         |
|                            | MS21042-3      | 6        | 209       | 0         |
|                            | MS21042L08     | 26       | 1,305     | 0         |
|                            | MS27039-08-19  | 12       | 827       | 0         |
|                            | MS27039-08-23  | 14       | 8         | 0         |
|                            | MS27039-1-19   | 6        | 226       | 0         |
|                            | NAS1149F0332P  | 12       | 2,994     | 0         |
|                            | NAS1149FN832P  | 136      | 3,136     | 0         |

## Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

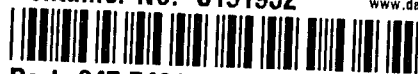
NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|--------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                        |              |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                        | MRB (QS1042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition            |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By           |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Lead hand / Supervisor |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | QC / QA Coordinator    |              |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                        |              |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |



Container No: S191952



Part: 647.7401

Job No: 190594

Serial No/Batch: S191952

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Email: sales@dartaero.com  
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Date: 05/19/19